

# Work Order ID 59917

June 17, 2010 8:19:50 AM



Page 1

Item ID: D3278-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Support					
Start Date: 18/06/2010	Start Qty: 60.00		Cust Item ID:		
Required Date: 23/06/2010	Req'd Qty: 60.00		Customer:		
Reference: <i>See 10.06.18</i>					
Approvals: Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start
QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3278	Rev C								
100	BAND SAW	0.00							
	Bandsaw	0.00							
Jeaspa Bandsaw	Memo Cut blank: 2.00" x 1.00" x 2.550" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo 1- Machine as per Folio FA405 and Dwg D3278-2- Deburr and Tumble Identify as D3278-1								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								

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Item ID: D3278-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 18/06/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 23/06/2010 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

B.A  
10/06/20

60

0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

ml

10

06

21

(60)



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

MH4841

Memo

0.00



Powdercoat

START TIME:

9:15

□OVEN TEMPERATURE:

320°

□FINISH TIME:

9:45

60

BR 10-6-22

Powder Coating

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Item ID: D3278-1

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Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 18/06/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 23/06/2010 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-6-22 SF (60)

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

10-6-22 SF 60x

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/23

U 10-06-23

# Picklist Print

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Work Order ID: 59917



Parent Item: D3278-1



Parent Item Name: Support

Start Date: 18/06/2010

Required Date: 23/06/2010

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: ☐A☐04.04.19☐New issue☐KJ/JLM☐  
IPP B 07.09.06 rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	32.5000	0.2337	14.76			



6061-T6 Bar 1.00 x 2.00

Location	Loc Qty	Loc Code
MAT	30.27	
114415	30.27	
MAT03	2.23	
112567	2.23	

14.76 S.P 10/06/17

+ Scrap 6 inches

DART AEROSPACE LTD		Work Order: 59917
Description: Support		Part Number: D3278-1
Inspection Dwg: D3278	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

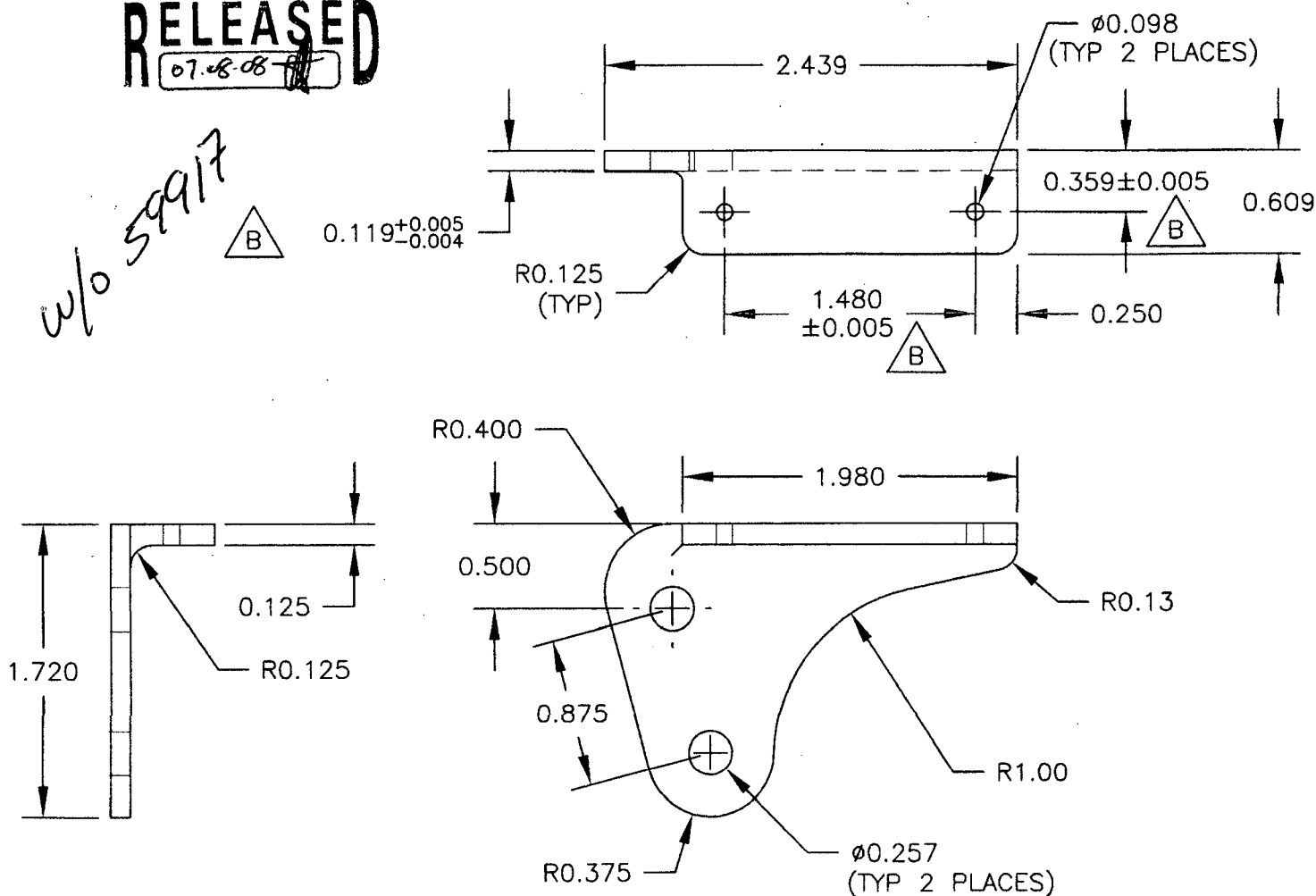
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.099	✓			
0.359	+/-0.005	.363	✓			
0.609	+/-0.010	.607	✓			
0.250	+/-0.010	.250	✓			
1.480	+/-0.005	1.481	✓			
R0.125	+/-0.010	.125	✓			
0.119	+0.005/-0.004	.120	✓			
2.439	+/-0.010	2.443	✓			
1.980	+/-0.010	1.982	✓			
R0.13	+/-0.030	.125	✓			
Ø0.257	+0.005/-0.000	.259	✓			
R0.375	+/-0.010	.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.502	✓			
R0.400	+/-0.010	.400	✓			
R1.00	+/-0.030	1.000	✓			
1.720	+/-0.010	1.725	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.129				

Measured by: B.S.	Audited by: J.A.	Prototype Approval:	N/A
Date: 10/06/18	Date: 10/06/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	BE

**DART**

DESIGN <i>qp</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

**RELEASED**  
07-08-08*w/o 59917***D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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